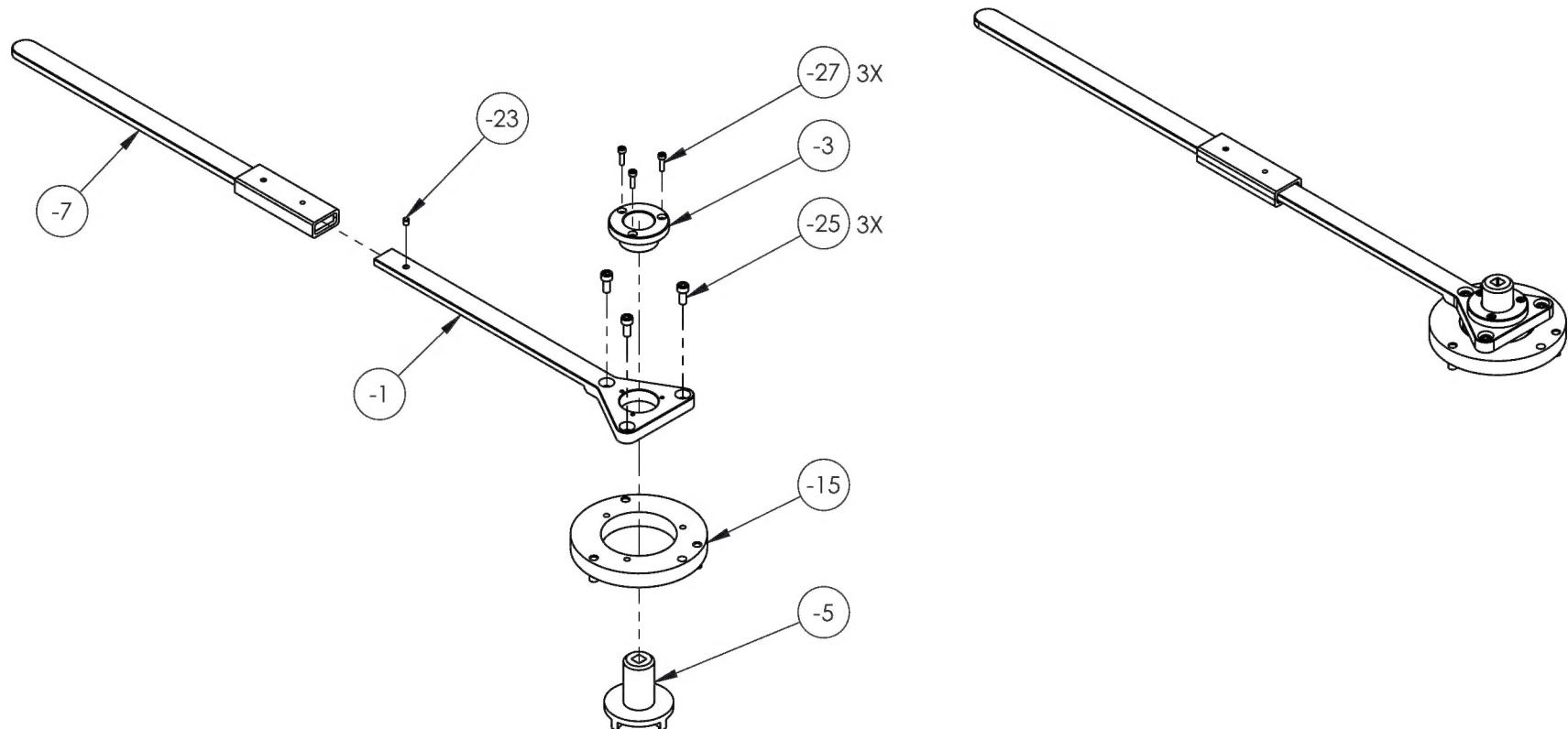


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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.			5/9/2016	DPD	JAG



ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				-1	1	HANDLE	6061		2
				-3	1	BUSHING	6061		3
				-5	1	SOCKET	4140/4142		4
X				-7	1	HANDLE EXTENSION ASSEMBLY			5
	1			-9		HANDLE EXTENSION	6061		6
X	1			-11		EXTENSION BLOCK WELDMNT			7
2				-13		HANDLE EXTENSION BLOCK	1018/1020 CR		8
X				-15	1	LARGE RING ASSEMBLY			9
1				-17		LARGE RING	6061		10
	1	B/O		-19		DOWEL PIN	STEEL	Ø1/4 X 3/4 (MCMASTER-CARR #98381A540)	5
3		B/O		-21		DOWEL PIN	STEEL	M10 X 32mm (MCMASTER-CARR #91595A650)	9
		B/O		-23	1	PLUNGER	S.S.	Ø.236 BODY X .24 BODY (MCMASTER-CARR #84895A73)	1
		B/O		-25	3	SOCKET HEAD CAP SCREW	S.S.	M8 X 1.25mm X 18mm (MCMASTER-CARR #91292A080)	1
		B/O		-27	3	SOCKET HEAD CAP SCREW	S.S.	M5 X 0.8mm X 18mm (MCMASTER-CARR #91292A127)	1
ASSY -15	ASSY -11	ASSY -7							

NOTES:
REF. AIRBUS T/N: M632V3007128.
PART OF KIT RBEM632V3007102.



NUT KEY

RBEM632V3007128

REV 1

MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	X ± .1 SURFACES = 125 ✓
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT H175
SCALE	1:8
DATE	3/15/2016
SHEET 1 OF 10	

USED ON MODEL

ASME Y14.5M-2009

1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R

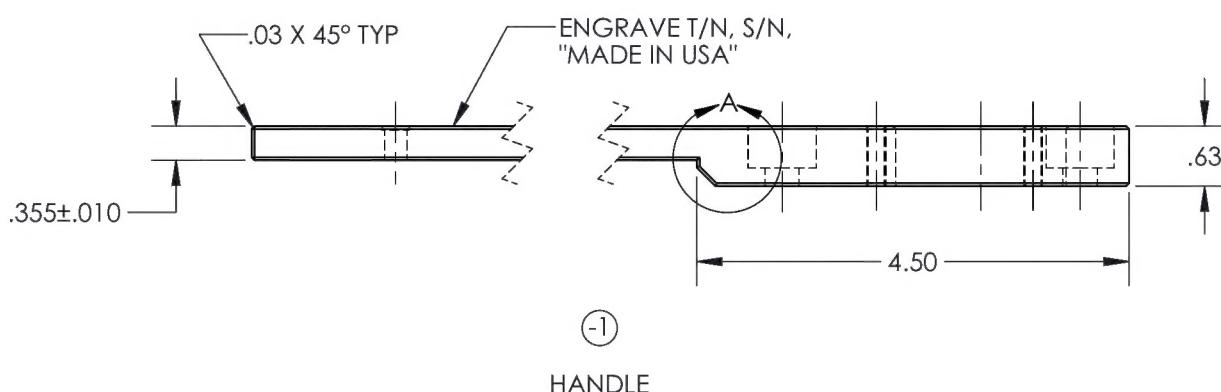
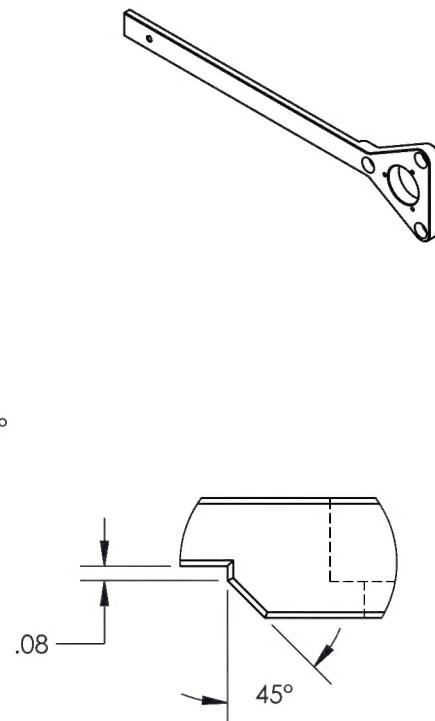
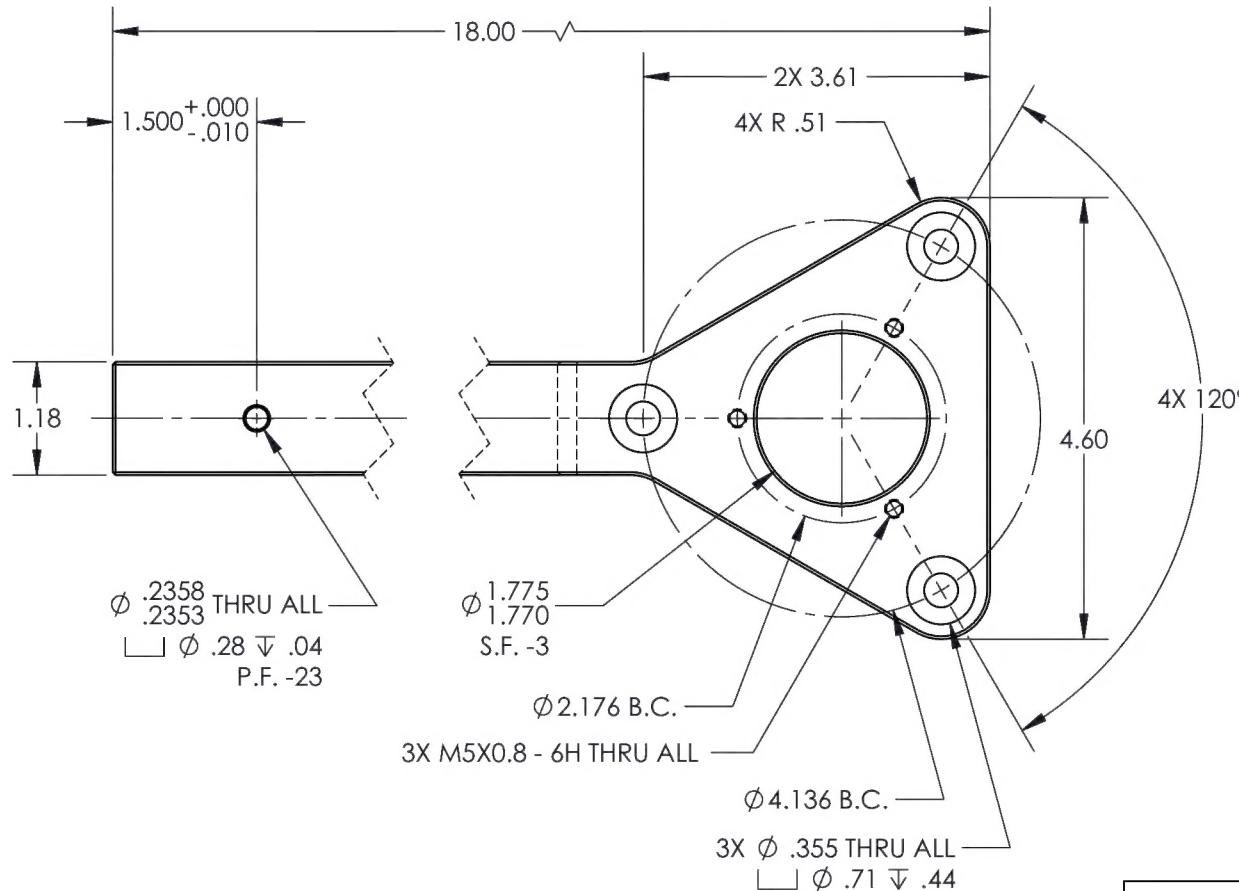
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING

3. INTERPRET DIM AND TOL PER

ASME Y14.5M-2009

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REV	ECR	REVISIONS		
		DESCRIPTION	DATE	INITIAL
				APPROVED



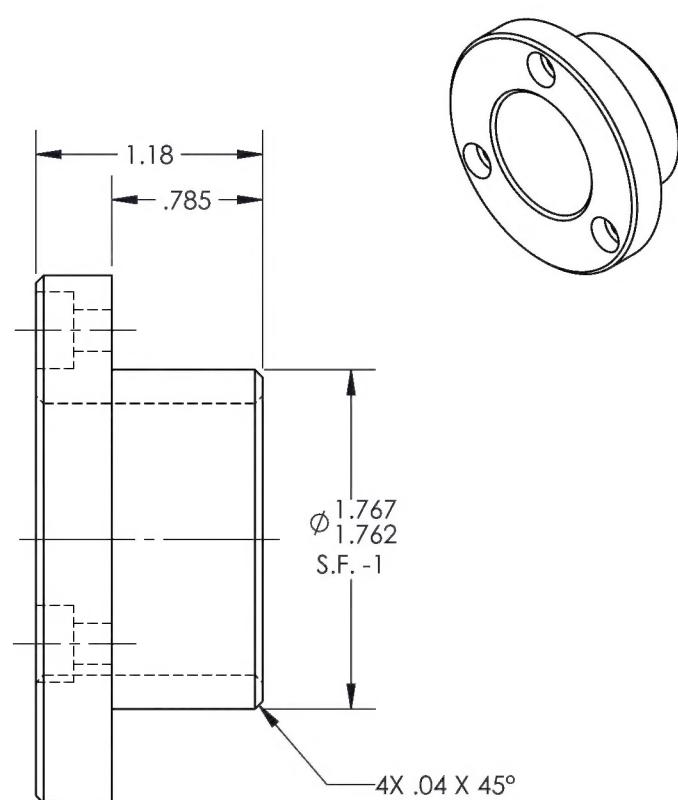
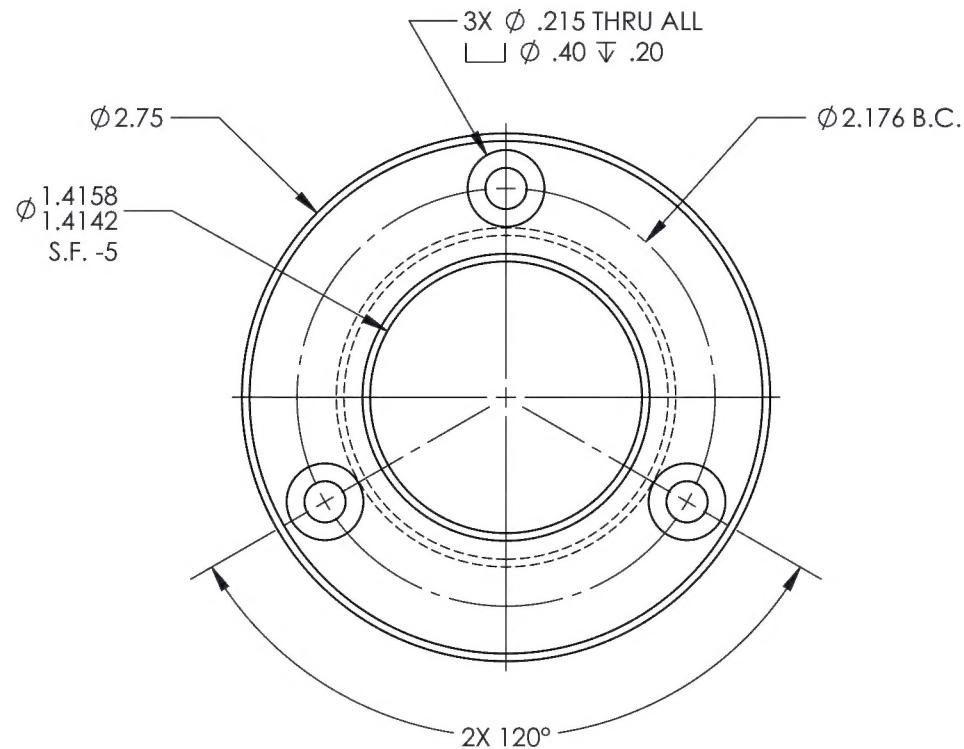
(1)

HANDLE

DART AEROSPACE	
TITLE	
DWG NO. RBEM632V3007128-1 REV 1	
MAT'L 6061	
HEAT	
TREAT	
FINISH CLEAR ANODIZE	
SPEC MIL-A-8625, TYPE II, CLASS I	
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT H175
SCALE 1:2	DATE 3/15/2016
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
SHEET 2 OF 10	

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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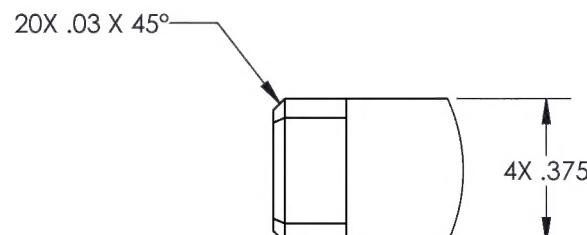
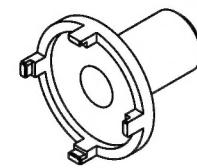
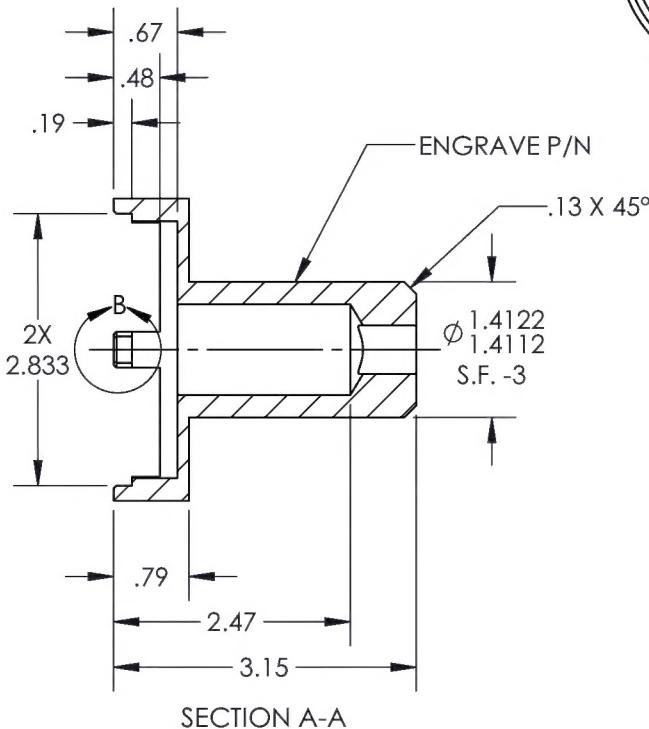
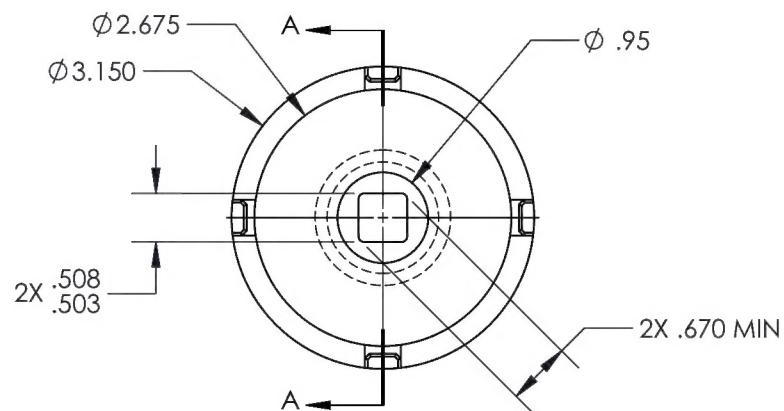


(3)
BUSHING

DART AEROSPACE	
TITLE	
NUT KEY	
DWG NO.	RBEM632V3007128-3
MAT'L	6061
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
HEAT	.XXX ± .005
TREAT	FRACTIONS ± 1/8
FINISH	.XX ± .01
ANGLES ± 5°	
SPEC	CLEAR ANODIZE
.X ± .1 SURFACES = 125 ✓	
SPEC	MIL-A-8625F, TYPE II, CLASS I
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
H175	
SCALE	1:1
DATE	3/15/2016
SHEET 3 OF 10	

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(5)
SOCKET

DETAIL B
SCALE 2 : 1

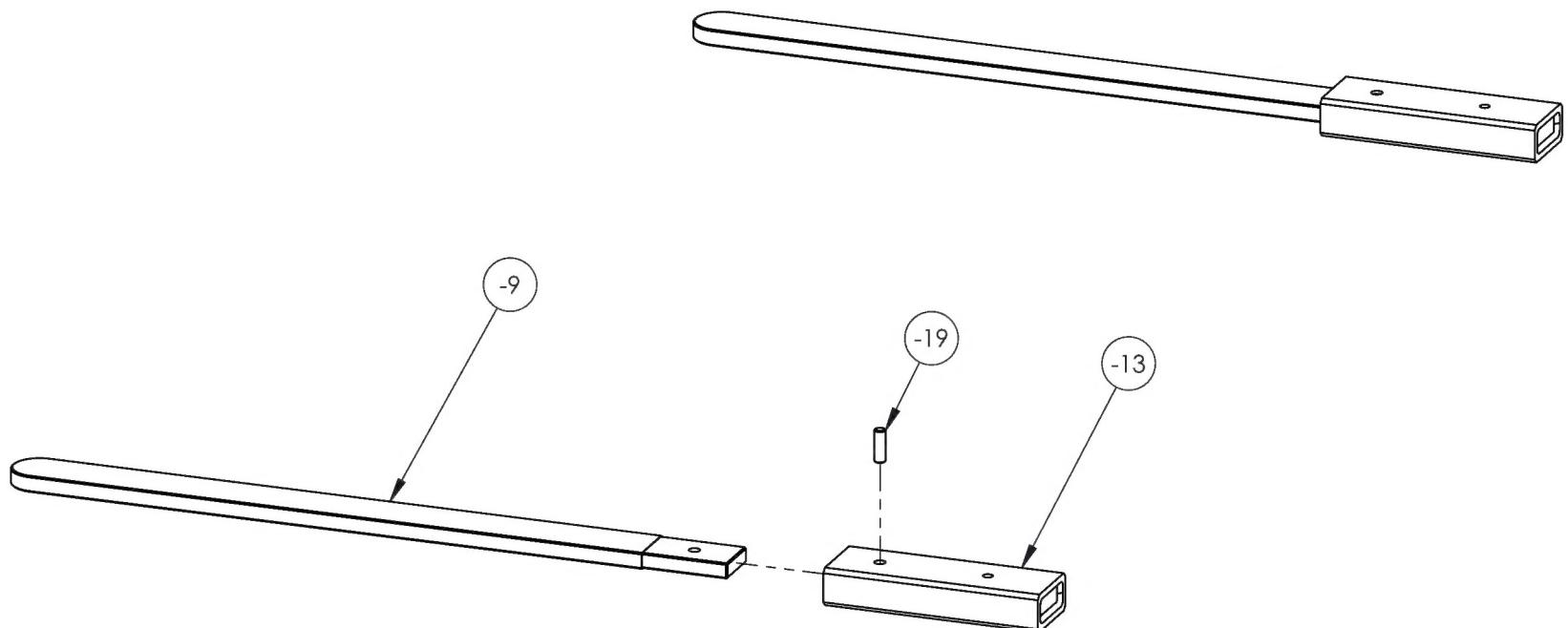
DART AEROSPACE	
TITLE	
NUT KEY	
DWG NO.	RBEM632V3007128-5
REV	1
MATERIAL 4140/4142	
HEAT RC 36-40	
TREAT	
FINISH ZINC PLATE	
SPEC ASTM B633 TYPE I SC 2	
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
H175	
SCALE	1:2
DATE	3/15/2016
SHEET 4 OF 10	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ± 5°
X ± .1 SURFACES = 125 ✓

- BREAK ALL SHARP EDGES
.015 x 45° OR .015R
- DIMENSIONAL LIMITS APPLY AFTER PLATING
- INTERPRET DIM AND TOL PER ASME Y14.5M-2009

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REV		ECR		DESCRIPTION		DATE	INITIAL	APPROVED
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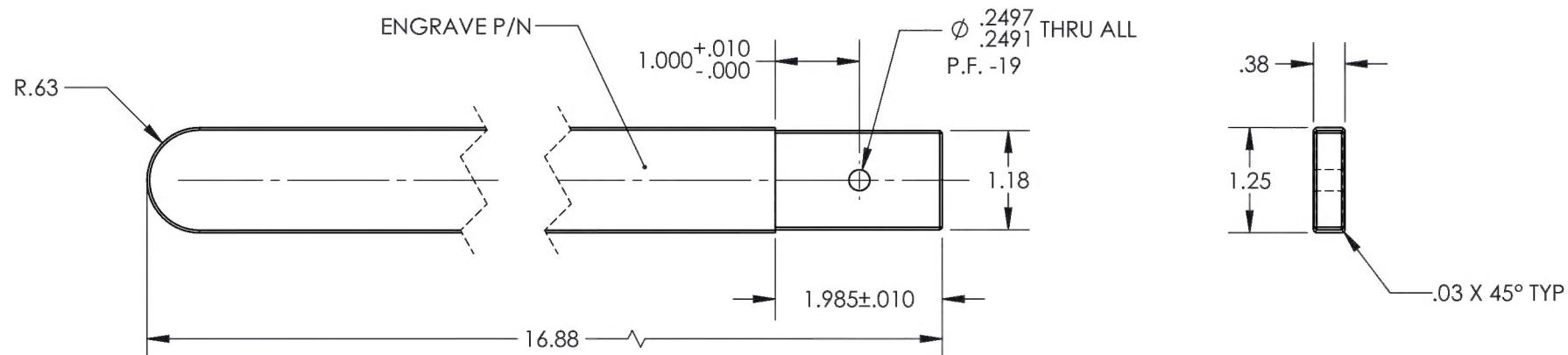
HANDLE EXTENSION ASSEMBLY

(-7)

DART AEROSPACE	
TITLE	
NUT KEY	
DWG NO.	RBEM632V3007128-7
REV	1
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX ± .005 FRACTIONS ± 1/8
TREAT	.XX ± .01 ANGLES ± 5°
FINISH	X ± .1 SURFACES = 125
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	1:4
DATE	3/15/2016
SHEET 5 OF 10	

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REV	ECR	REVISIONS		
		DESCRIPTION	DATE	INITIAL
				APPROVED



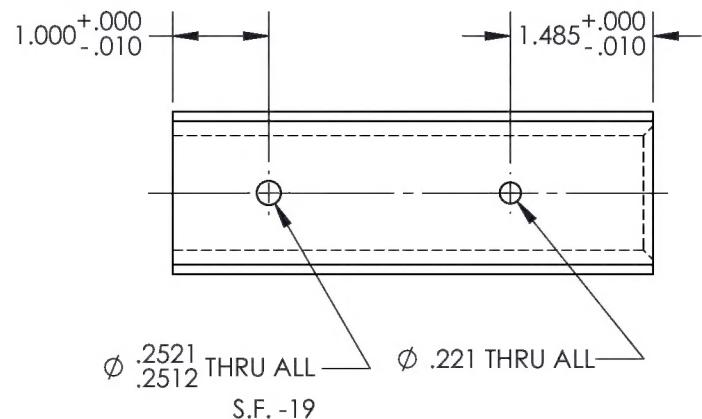
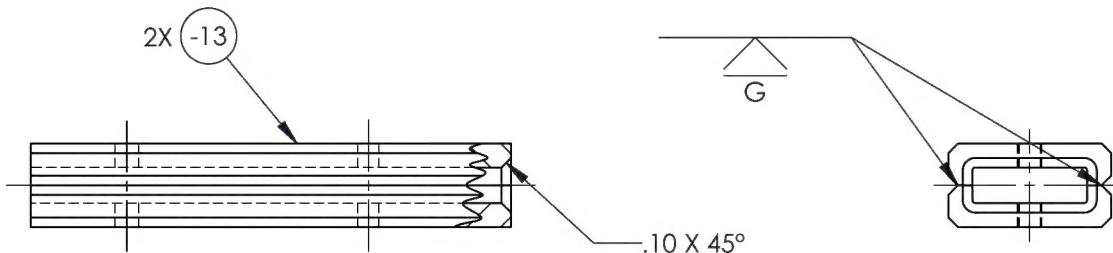
HANDLE EXTENSION

(-9)

DART AEROSPACE	
TITLE	
NUT KEY	
DWG NO. RBEM632V3007128-9	
REV 1	
MATERIAL 6061 UNLESS OTHERWISE SPECIFIED HEAT TREAT FRACTIONS ± 1/8 FINISH CLEAR ANODIZE ANGLES ± 5° SURFACES = 125	
SPEC MIL-A-8625F, TYPE II, CLASS I DRAWN BY: DUERFELDT CHECKED: CLOUGH OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
SCALE 1:2	DATE 3/15/2016
SHEET 6 OF 10	

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(-11)

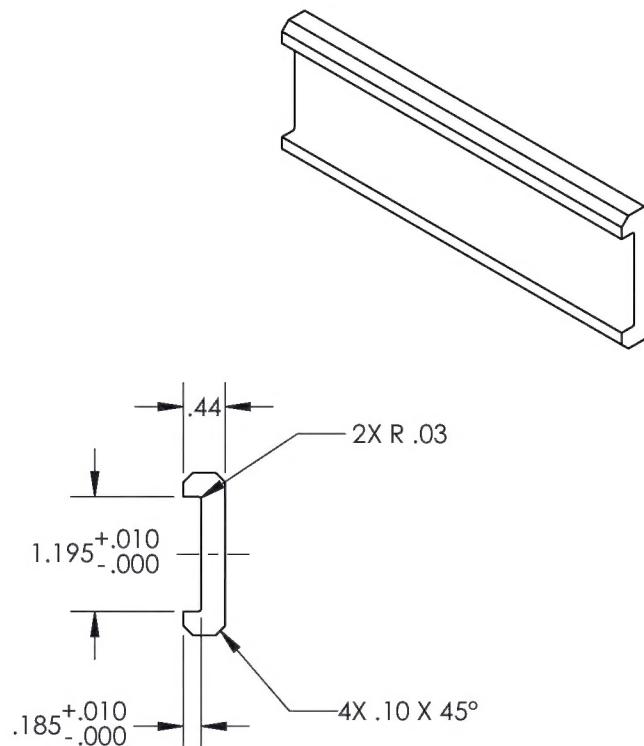
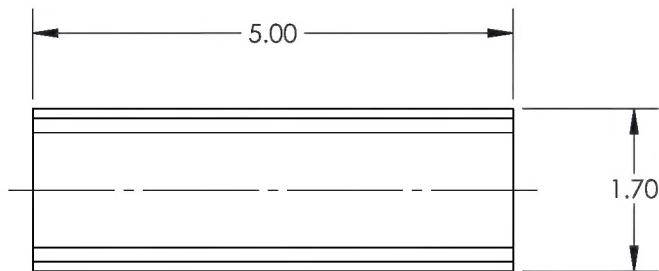
EXTENSION BLOCK WELDMENT

NOTE:
MACHINE AFTER WELD.

DART AEROSPACE	
TITLE	
NUT KEY	
DWG NO.	RBEM632V3007128-11
REV	1
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX ± .005 FRACTIONS ± 1/8
TREAT	.XX ± .01 ANGLES ± 5°
FINISH	X ± .1 SURFACES = 125 ✓
SPEC	ASTM B633 TYPE I SC 2
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	1:2
DATE	3/15/2016
SHEET 7 OF 10	

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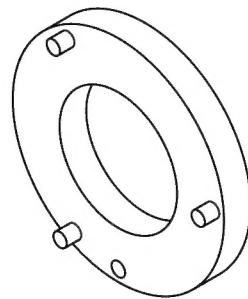
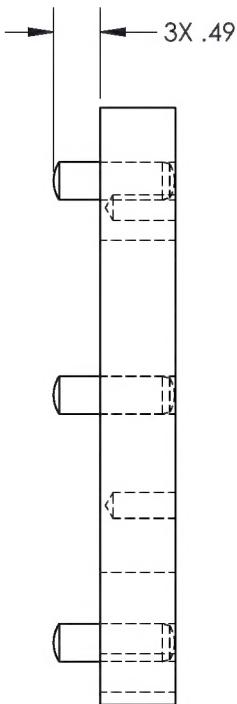
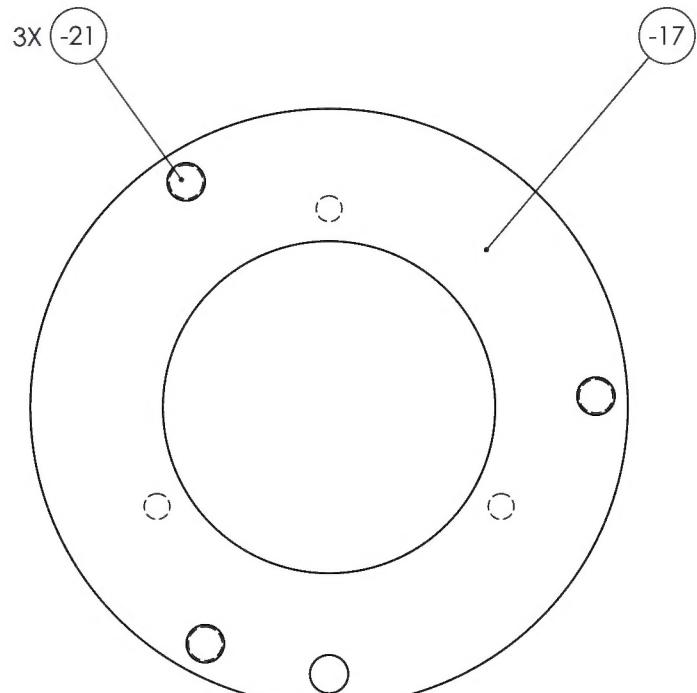
DART AEROSPACE	
TITLE	
NUT KEY	
DWG NO.	RBEM632V3007128-13
REV	1
MATERIAL 1018/1020 CR	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT	.XXX ± .005 FRACTIONS ± 1/8
TREAT	.XX ± .01 ANGLES ± 5°
FINISH SEE -11	X ± .1 SURFACES = 125 ✓
SPEC	
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	1:2
DATE	3/15/2016
SHEET 8 OF 10	

-13

HANDLE EXTENSION BLOCK

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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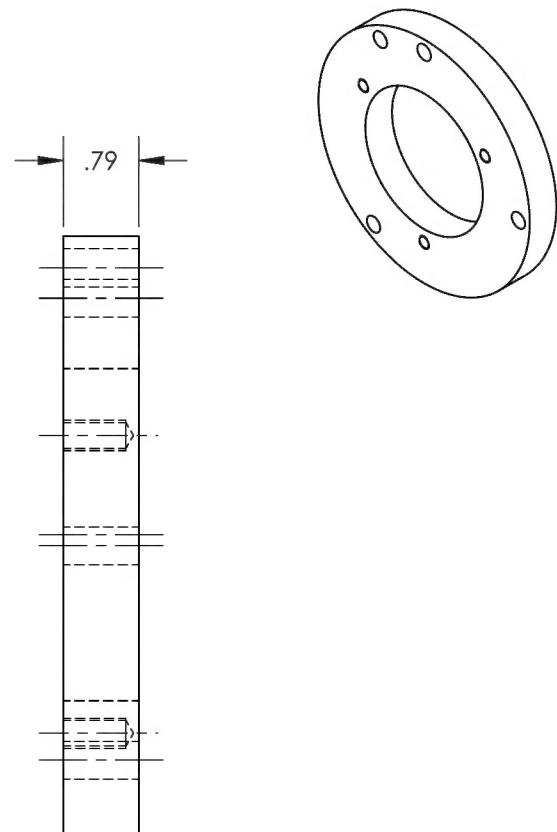
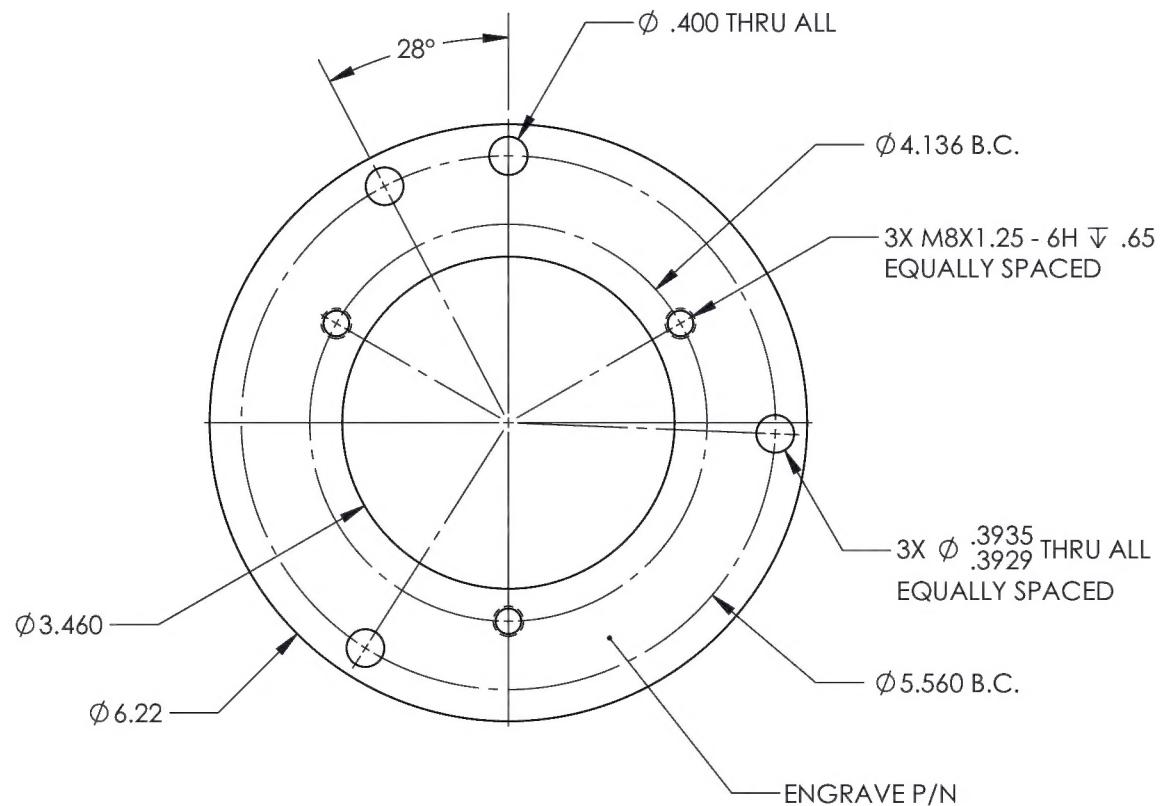


LARGE RING ASSEMBLY

DART AEROSPACE	
TITLE	
NUT KEY	
DWG NO.	RBEM632V3007128-15
REV	1
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
MAT'L	.XXX ± .005 FRACTIONS ± 1/8
HEAT	.XX ± .01 ANGLES ± 5°
TREAT	X ± .1 SURFACES = 125 ✓
FINISH	
SPEC	
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	1:2
DATE	3/15/2016
SHEET 9 OF 10	

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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DART AEROSPACE	
TITLE	
NUT KEY	
DWG NO.	RBEM632V3007128-17
REV	1
MAT'L 6061	
HEAT TREAT	
FINISH CLEAR ANODIZE	
SPEC MIL-A-8625, TYPE II, CLASS I	
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	1:2
DATE	3/15/2016
SHEET 10 OF 10	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ± 5°
X ± .1 SURFACES = 125 ✓

1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009